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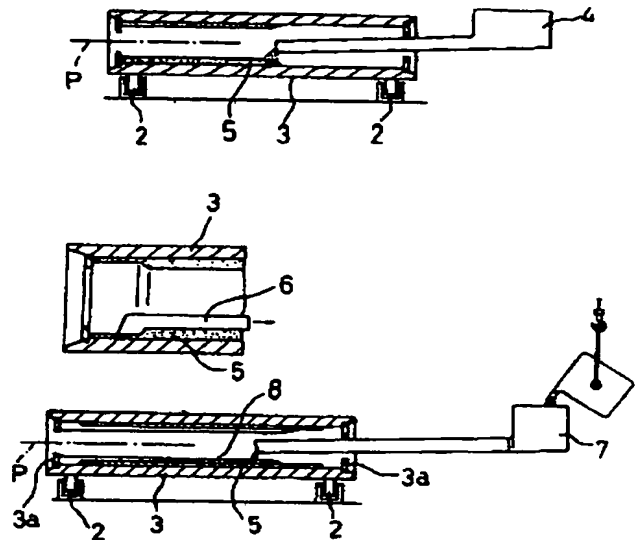
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TITLE : CENTRIFUGAL CASTING METHOD
FOR MOLD MATERIAL AND
BOTH-FLANGED PIPE



ABSTRACT : **PURPOSE:** To perform in an excellent state the centrifugal casting of a both-flanged pipe made of a metallic material requiring quick cooling, by making a mold material of a metallic granular body and a powdery body packing its gaps and then by molding it on the internal surface of a metal mold by kneading them with a binder.

CONSTITUTION: A metallic granular body, such as Cu, Al, Mg, and Fe, having 0.3–0.6mm grain size and a packing powdery body, such as ≤ 200 meshes graphite, Al, Cu, and silica, are mixed at 9:1–5:5. With this mixture, a 3–10% binder, such as water glass and phenol resin, is mixed and kneaded sufficiently to obtain a mold material. While cylindrical metallic mold 3 mounted on supporting roller 2 laterally is revolved around center shaft P, the said mold material is supplied from oscillating feeder 4 and the mold material is formed into cylindrical mold 4 by making use of centrifugal force. Next, the internal circumferential side of mold 5 is formed with shaping board 6 to form a both-flanged pipe, making it possible to cast the both-flanged pipe by the centrifugal force.

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